

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000510**Date Inspected:** 18-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Bing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 and 89 meter elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Mock-up 77 Meter Elevation Ultrasonic testing (UT) repairs

The QA inspector performed dimensional verifications of the excavated areas located at the skin A and E. The approximately percentages of the length excavated and being repaired by ZPMC for every 2000 mm of length are listed as follows:

Skin A

Joint # 1, 30 %

Joint # 2, 90 %

Joint # 3, 52 %

Joint # 4, 55 %

Skin E

Joint #1, 26 %

Joint #2, 78 %

Joint #3, 50 %

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Tower Mock-up 89 Meter Elevation

The QA performed ultrasonic testing (UT) on the side A & B at the junction of the diaphragm plates SA-1236 and A13. The evaluation of the top quarter, middle half and bottom quarter was performed with the 70°angle wedge transducer. The QA inspector performed 20 % Ultrasonic testing (UT) verifications on the top diaphragm splice plate SA-104 at the Y location marks 700 mm to 1100 mm. The QA inspector discovered that the weld areas tested appeared to be in general compliance with AWS D1.5 2002. See UT report TL_6027 generated on this date.

Note: ZPMC & ABF at this time had not provided weld maps for this Tower Mock-up in accordance with contract documents.

Summary of Conversations:

The QA inspector had a conversation with Task Leader Robert Cuellar. Mr. Cuellar relayed to the QA inspector that due to the inclement weather conditions ZPMC would stop working on the fabrication for the San Francisco Oakland Bay Self Anchored Suspension Bridge at 1300 hours on this date until further notice.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
